

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022148**Date Inspected:** 20-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3009C

Weld No: 239~241

Welder: 051359

WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019BB

Weld No: 011, 012, 033, and 034

WR: 20467

Welder: 215553

WPS-345-SMAW-3G(3F)-FCM-Repair-1

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PCMK: SEG-3019BB

Weld No: 0055, 056, 100, 108, and 144

WR: 20467

Welder: 216086

WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3009AJ

Weld No: 054, 080, 096, and 104

WR: 20468

Welder: 054013

WPS-345-SMAW-3G(3F)-FCM-Repair-1

PCMK: SEG-3009AJ

Weld No: 108, 113, 118, and 119

WR: 20468

Welder: 044779

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019B

Weld No: 001

Welder: 051356

WPS-B-T-2232-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SB27-001-110E

Weld No: 022 and 033

Welder: 062814

WPS-B-P-2121-TC-U4b-FCM-1

PCMK: SB26-001-110W

Weld No: 026

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Welder: 062772

WPS-B-P-2212-TC-P4-FCM-1

Bay 19

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: X6041A

Weld No: Surfacing

CWR: 2835

Welder: 062806

WPS-345-FCAW-1G-ESAB-FCM-Repair

PCMK: X6041B

Weld No: Surfacing

CWR: 2835

Welder: 062783

WPS-345-FCAW-1G-ESAB-FCM-Repair

PCMK: X6043A

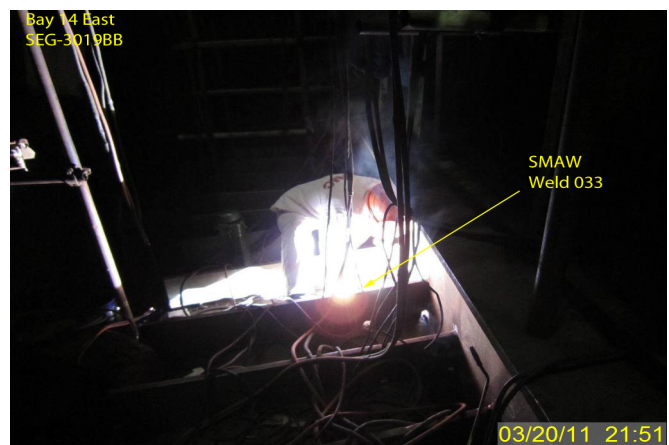
Weld No: Surfacing

CWR: 2835

Welder: 062749

WPS-345-FCAW-1G-ESAB-FCM-Repair

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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### Summary of Conversations:

No relevant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Rice,Brett	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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